












File: Wednesday, 4/4/2007 8:52:02 AM  
User: Kim Johnston

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CLAMP KIT
Job Number	: 31579		
Estimate Number	: 12475		
P.O. Number	: N/A	Part Number	: D119756011
This Issue	: 4/4/2007 S.O. No. : N/A	Drawing Number	: PRELIMINARY Rev. C 07.04.09
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: PREL Rev. C
Previous Run	: 29563	Material	: N/A
Written By	: _____	Due Date	: 4/30/2007 Qty: 7 Um: Each
Checked & Approved By	: _____		
Comment	: Est Rev:A New Issue 06-06-27 JLM Est rev B Rev B dwg, picklist 06.07.26 EC		

## Additional Product

Job Number:			
Seq. #	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	
		 (7)	
Comment: Photocopy bluefile & type labels per PPPD119-756-011 CHG001 KS 07.04.20			
2.0	PACKAGING 1	PACKAGING RESOURCE #1	
			
Comment: PACKAGING RESOURCE #1 Pick Packing Kit			
3.0	D26173	Bushing	
			
Comment: Qty.: 2.0000 Each(s)/Unit Total : 14.0000 Each(s) Bushing Batch: B27738 8 B29791 6			
4.0	D26175	Spacer	
			
Comment: Qty.: 4.0000 Each(s)/Unit Total : 28.0000 Each(s) Spacer Batch: B31033 20 4 8 B31610 7/5/2 50			
5.0	D2732	Rubber Extrusion	
			
Comment: Qty.: 1.0666 f(s)/Unit Total : 7.4662 f(s) RUBBER CUSHION 4 X 3.200" LONG Batch: B26472 7/4/16 50			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP KIT

Job Number: 31579

Part Number: D119756011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2856400

Abrasion Strip



Comment: Qty.: 0.6382 f(s)/Unit Total : 4.4674 f(s)

Abrasion Strip

Cut into (2) halves to make D2856-200-766 (7.66" LONG )

QTY OF 2

Batch: ~~B29850~~ B29850 ✓

7.0

D30411

Clamp



Comment: Qty.: 1.0000 Each(s)/Unit Total : 7.0000 Each(s)

Clamp

Batch: B26217 ✓

8.0

D30413

Clamp



Comment: Qty.: 1.0000 Each(s)/Unit Total : 7.0000 Each(s)

Clamp

Batch: B30890 ✓

9.0

D30415

Clamp



Comment: Qty.: 1.0000 Each(s)/Unit Total : 7.0000 Each(s)

Clamp

Batch: B28686 ✓

10.0

D30417

Clamp



Comment: Qty.: 1.0000 Each(s)/Unit Total : 7.0000 Each(s)

Clamp

Batch: B29687 ✓

11.0

AN417A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 14.0000 Each(s)

Bolt

Batch: M101124<sup>8</sup> ✓ M102280 ✓

12.0

AN420A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 14.0000 Each(s)

Bolt

batch: M16895 ✓

7/4/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/05/04

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: CLAMP KIT

Job Number: 31579

Part Number: D119756011

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

AN960JD416

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 28.0000 Each(s)

Washer

Batch: M102929

14.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 28.0000 Each(s)

Nut

Batch: M103914

15.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

C2071051030

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D119-756-011

Location:

PPP Rev: DRAFT

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 07-05-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## 7.0 PARTS LIST

Qty-041	Qty-011	Qty-013	Part Number	Description
X			D119-756-041	HELI-UTILITY-BASKET™
1	X		D119-756-011	CLAMP KIT
		X	D119-756-013	QUICK RELEASE KIT
2			D2022-101	* SPACER
1			D2258-220	* PLACARD
1			D2332-041	* PROP ASSEMBLY
1			D2530	* HANDLE ASSEMBLY
2			D2535	* SPRING
2			D2537	* BUSHING
2	2		D2617-3	BUSHING
4	4		D2617-5	BUSHING
	4		D2732-032	RUBBER CUSHION
	2		D2856-200-766	ABRASION STRIP
2			D2931	* BUMPER
	1		D3041-1	CLAMP
	1		D3041-3	CLAMP
	1		D3041-5	CLAMP
	1		D3041-7	CLAMP
1			D3515-041	* BASKET LID ASSEMBLY
1			D3516-041	* BASKET BASE ASSEMBLY
2			D3516-11	CLEVIS
2			D3517-1	STRUT
2			D3518-041	STRUT ASSEMBLY
2			D3519-1	* PLACARD
2			D3520-1	SPACER
2			AN3-16A	* BOLT
2			AN4-7A	* BOLT
2			AN4-13A	BOLT
6			AN4-15A	BOLT
	2		AN4-17A	BOLT
2	2		AN4-20A	BOLT
1			AN4-22A	* BOLT
1			AN4-24A	* BOLT
2			AN5-10A	BOLT
4			AN5-17A	* BOLT
2			AN960JD416	* WASHER
40	4		AN960JD416	WASHER
2			AN960JD416L	* WASHER
4			AN960JD416L	WASHER
4			AN960JD516	* WASHER
2			AN960JD516L	WASHER
2			AN960JD8	* WASHER
4			AN970-4	* WASHER
		4	BLRS-020	POSITIVE LOCKING QUICK RELEASE PIN
2			MS20600AD4W3	* RIVET
2			MS21042L3	* NUT (OR MS21042-3)
4			MS21042L4	* NUT (OR MS21042-4)
10	4		MS21042L4	NUT (OR MS21042-4)
4			MS21042L5	* NUT (OR MS21042-5)

\* indicates that part is pre-assembled on basket for customer